






File Red

Dart Aerospace Ltd.

Date: Tuesday, 27/01/2009 11:11:52 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GUIDE
Job Number : 45280	
Estimate Number : 11216	
P.O. Number :	Part Number : D33335
This Issue : 27/01/2009 S.O. No. :	Drawing Number : D3333 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 45083	Material :
Written By :	Due Date : 15/02/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JULIE DAWSON</u>	
Comment : Est. A05.01.13 New issue KJ/JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation:
Description :	
1.0	M1010B1500X01000 1010-1025 Steel Bar 1.500 x 1.00
	
Comment: Qty.: 0.6672 f(s)/Unit Total: 6.6717 f(s) AISI 1010-1025 Steel Bar Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel (M1010-B1.500x01.000) Identify for D3333-5 Batch: <u>M110740</u>	
2.0	BAND SAW BAND SAW
	
Comment: BAND SAW Cut blanks: 1.500" x 1.000" thick x 7.500" long	
3.0	HAAS1 HAAS CNC VERTICAL MACHINING #1
	
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA484 and Dwg D3333 Tap holes as per Dwg D3333 Deburr <u>B 9-2-9</u> Identify as D3333-5	
4.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 27/01/2009 11:11:52 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 45280

Part Number: D33335

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

DT 09/02/06 (10)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- pass parts in deburring machine

IB 9-2-9

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/02/09 (x10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3
Ensure to mask threaded holes

START TIME: 8:15am

OVEN TEMPERATURE: 320°C

FINISH TIME: 8:45am

M102391

915 09-02-18 (10)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9/2/18 (10)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 493 9/2/18 (10)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/2018

Job Completion



MF 09-02-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45280
Description: Rail		Part Number: D3333-5
Inspection Dwg: D3333	Rev: B	Page 1 of 1

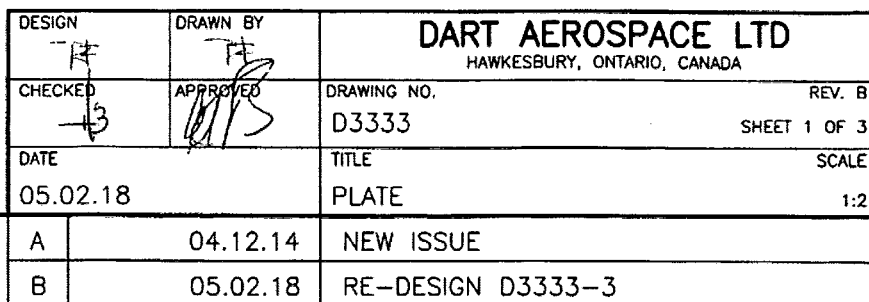
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

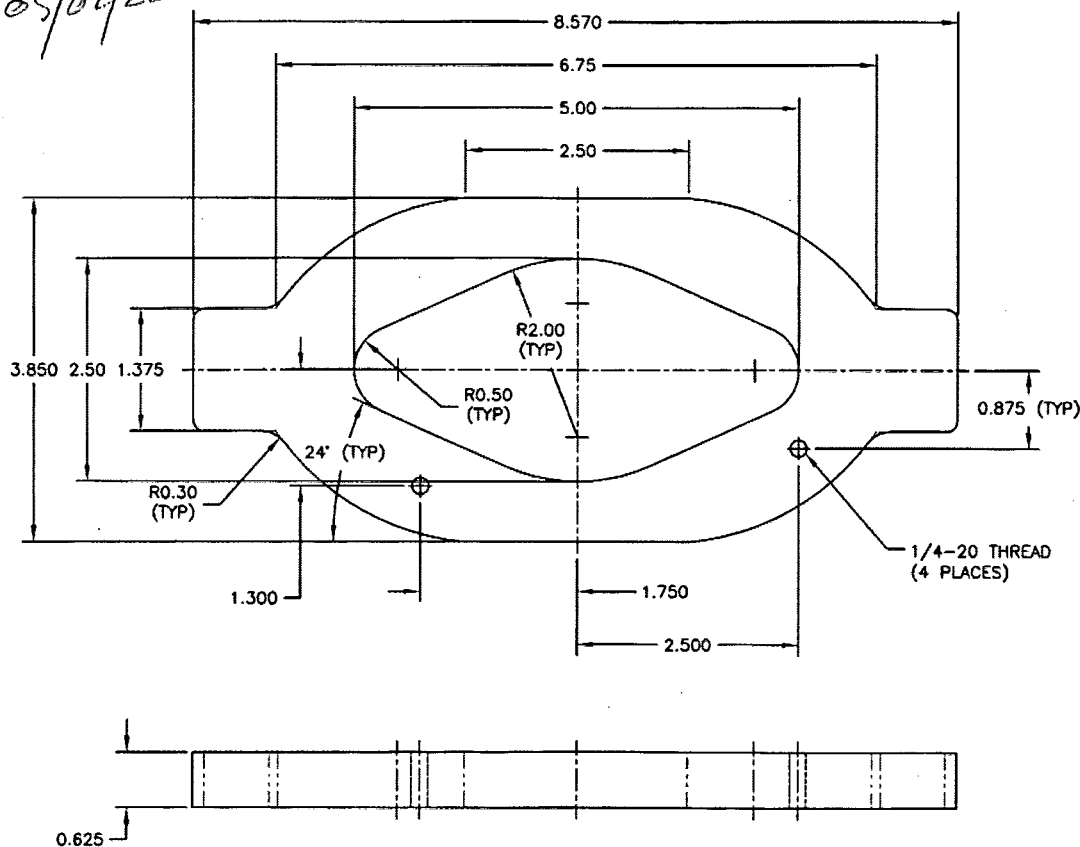
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.390	+/-0.010	0.389	✓			
0.506	+0.000/-0.006	0.502	✓			
7.50	+/-0.030	7.50	✓			
6.000	+/-0.010	5.997	✓			
2.000	+/-0.010	1.998	✓			
0.750	+/-0.010	0.745	✓			
1.25	+/-0.030	1.250	✓			
0.506	+/-0.010	0.505	✓			
Ø0.313	+0.005/-0.001	Ø0.314	✓			
1.00	+/-0.030	0.996	✓			
0.500	+/-0.010	0.505	✓			
3.750	+/-0.010	3.748	✓			

Measured by: N.A	Audited by: DJP	Prototype Approval:	N/A
Date: 09/02/06	Date: 09/02/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	08.11.28	Tolerance for 0.506 dimension revised	KJ/EC	



RELEASED
05/02/22



D3333-1 BASE PLATE PANEL

NOTES:

- 1) MATERIAL: AISI 4140 STEEL 0.625 THICK STEEL (REF. DART SPEC. M4140-B) RETURN TO
MIN. YIELD TENSILE STRENGTH = 100 ksi ENGINEERING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005U43 CONTROLLED COPY
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SUBJECT TO APPROVAL
- 4) ALL DIMENSIONS ARE INCHES WITHOUT DIMENSION
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 WORK CENTER

SHOP COPY

-RETURN TO

ENGINE 2101

U4:3CONTROL TO COM Y

SUBJECT TO APPROVAL OF


WITHOUT FURTHER DELAY.

WEEK 10

NO 75280

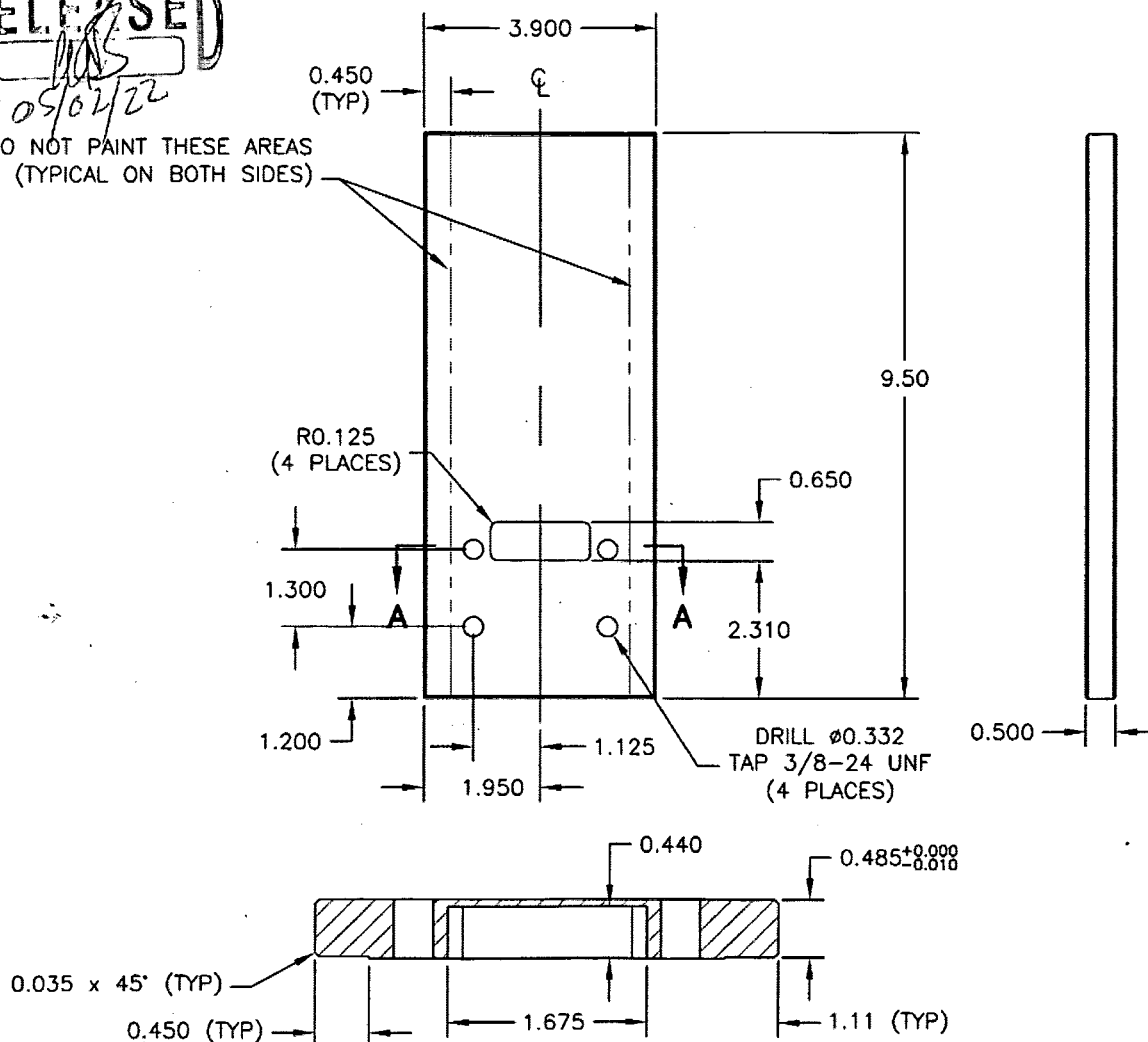
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DESIGN 17	DRAWN BY 17	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED 	DRAWING NO. D3333	REV. B SHEET 2 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:4

RELEASED

DO NOT PAINT THESE AREAS
(TYPICAL ON BOTH SIDES)



SECTION A-A

D3333-3 SLIDING PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 0.50 THICK
MILD STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

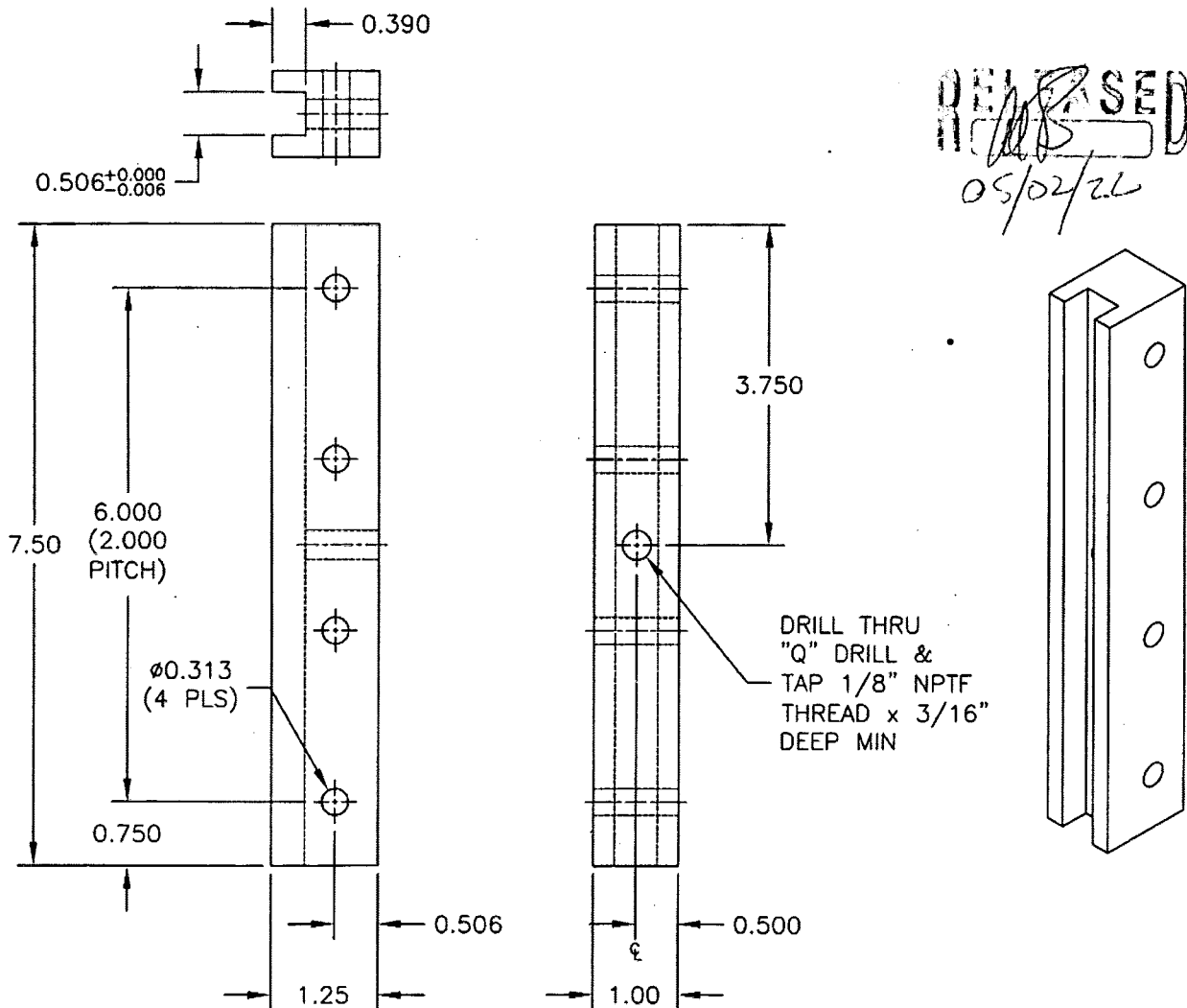
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DART

DESIGN TH	DRAWN BY TH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED [Signature]	DRAWING NO. D3333	REV. B SHEET 3 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:2

**D3333-5 RAIL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.00 THICK STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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